

Date: Tuesday, 15/07/2008 4:13:12 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	AFT TUBE ASSEMBLY
Job Number :	40525		
Estimate Number :	10699		
P.O. Number :		Part Number :	D3391025
This Issue :	15/07/2008	Drawing Number :	D3391 REV G
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	/ /	Drawing Revision :	G
Previous Run :	40524	Material :	
Written By :		Due Date :	08/08/2008
Checked & Approved By :	JUL 08.07.16	Qty:	1 Um: Each
Comment :	Est Rev B 06-02-07 ECN773 dwg rev. D EC Est Rev:C 06-03-28 Update Manuf. Instructions JLM est rev D 07.03.20 revF dwg EC est rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD Est Rev:F 07-11-13 ECN 1056 DD verified by: EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D6014090	ALUMINUM EXTRUSION
-----	----------	--------------------



Comment: Qty.: 1.0000 f(s)/Unit Total: 1.0000 f(s)

ALUMINUM EXTRUSION

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D6014-090	Extrusion	B32309
---	-----------	-----------	--------

Identify as D3391-3

a.m 08.07.30①

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------

**Comment:** MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA599

Rev: AA & Dwg D3391 Rev: G

a.m 08.07.30①

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

a.m 08.07.30①

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------

**Comment:** HAAS

1-Machine as per Folio FA 599 Rev: AA & Dwg D3391 Rev: G

2-Deburr

J-h 08/08/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 4:13:12 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 40525

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/08/01

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SE 08/08/01

7.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

DP 8-8-5

8.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: NC Bender

Form as per Dwg D3391. Using Bend Prog 3391025

DP 8-8-5

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/05

10.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig .

*****Do Not Open To Finished Size*****

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.

5-Open wearplate holes to 0.250" and c/sink as per dwg D3391

6-Open up all wearshoe , wearplate and float bag holes as per Dwg D3391.

7-Deburr

M 2-8-6

H 8-8-7

Tools: mill

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 4:13:12 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 40525

Part Number: D3391025

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

11.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

8 08/08/18 @

12.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
------	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Qm 08.08.08 @

13.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
------	-----	---



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M 7-8-12

14.0	D36704200	SPACER
------	-----------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

SPACER

batch: B3688

Q M 7-8-12

15.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
------	-------------	-----------------------



Comment: LANDING GEAR RESOURCE 1

Instal spacers as per dwg D3391

A/R Magnabond 6398 Batch: M107621

exp. date: 9-8-1

cure time 12hrs as per QSI0015

M 7-8-12

16.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

7-8-18 @

17.0	POWDER COATING	POWDER COATING
------	----------------	----------------



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:40
320 °C
1:15

M-P 08/08/18

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 4:13:12 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 40525

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HS



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-09-09

(14)

19.0

D2646

Aft Cap



*

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Cap

Pick:

Qty	Part Number	Description	Batch
1	D2646	Aft Cap	

B332427

m-h

20.0

D35371

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARPAD

B338941

m-h

21.0

D35377

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Wearpad

B333869

m-h

22.0

D35531

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Gasket

B333868

m-h

23.0

D35533

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Gasket

B333870

m-h

24.0

D36721

Phenolic Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
PHENOLIC WASHER

B339275

m-h

25.0

ALS41032130

Insert



*



(14)

Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)
INSERT
batch: M105819

m-h 08/09/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 4:13:12 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 40525

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

or equivalent per
QSI 017

26.0

ALS41032225

Insert



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

INSERT

or equivalent
Per QSI 017

M106489

M. J.

27.0

AN3C4A

BOLT



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch
2 AN3C4A Bolt

M109148

M. J.

28.0

AN3C5A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

M108744

M. J.

29.0

AN960C10L

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Inventory

Pick:

Qty Part Number Description Batch
2 AN960C10L Washer

M109147

M. J.

30.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install inserts as per Dwg D3391

2-Install Aft Cap as per Dwg D3391

A/R Sikaflex-241/-291

Sikaflex expiry date:

M108801

08/10

M. J.

08/09/10

(IX)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 4:13:12 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 40525

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/09/10

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

811 40525

33.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/10

Job Completion



4 08-09-10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 40525
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391	Rev: G	Page 1 of 1

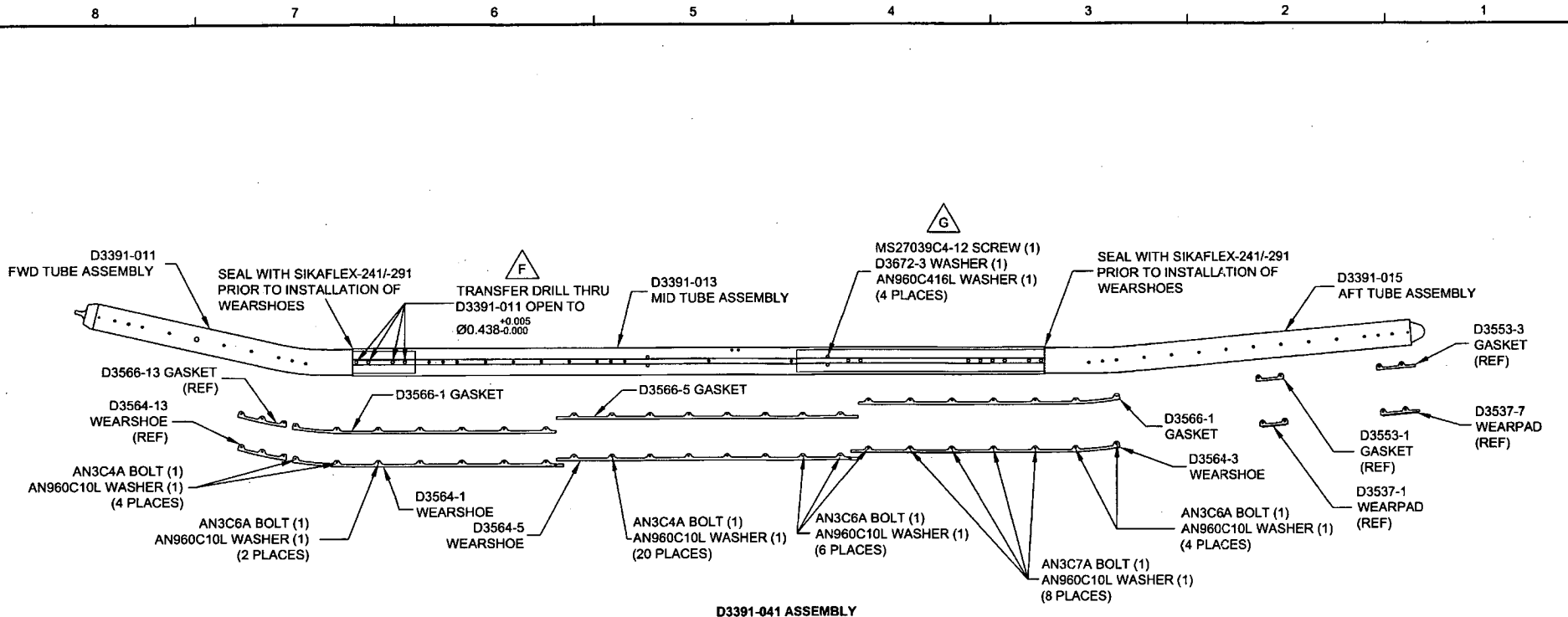
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.000	+/-0.010	14.000	✓			
3.500	+/-0.010	3.496	✓			
88.93	+/-0.030	88.920	✓			
44.995	+/-0.030	44.995	✓			
3.200	+/-0.010	3.210	✓			
1.526	+0.000/-0.030	1.523	✓			
0.200	+/-0.010	.204	✓			
7.500	+/-0.010	7.500	✓			
27.750	+/-0.010	27.750	✓			
31.750	+/-0.010	31.750	✓			
35.250	+/-0.010	35.250	✓			
3.300	+/-0.010	3.298	✓			
0.200	+/-0.010	.201	✓			
3.520	+/-0.010	3.526	✓			
0.687	+0.010/-0.000	.688	✓			
R0.062	+/-0.010	.062	✓			
Ø0.484	+0.005/-0.001	.486	✓			

Measured by: a.m./J.L.	Audited by: B.S.	Prototype Approval:	N/A
Date: 08.07.30	Date: 08/08/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	



D3391-041 ASSEMBLY

RELEASED
27-11-06

D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
6	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C10L	WASHER

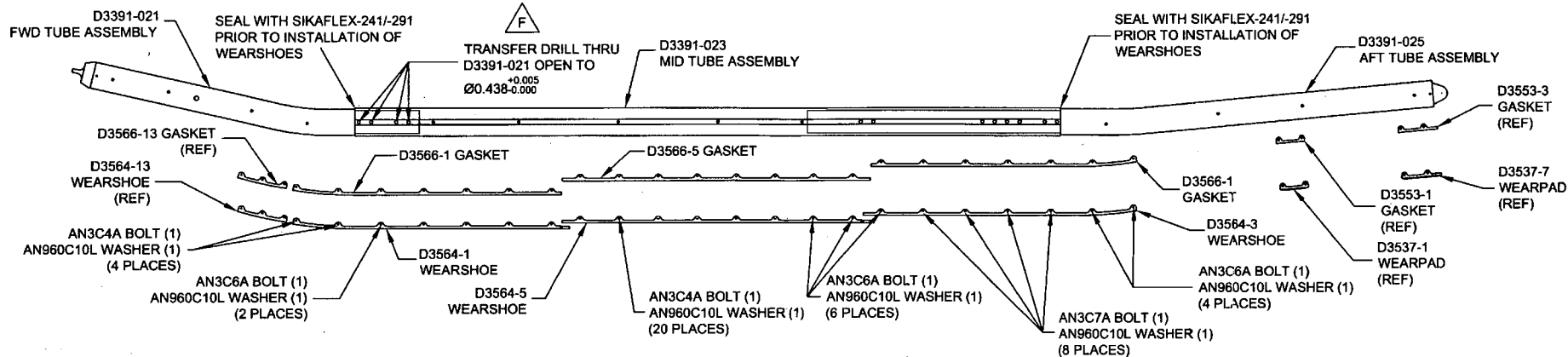
GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
OFF POWDER COATING WITH MEK DEGREASER.
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.

G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -0111-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	JP		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP		
DATE	07.07.31		
DART AEROSPACE USA, INC PORT HADLOCK, WA			
DRAWING NO. D3391		REV. G SHEET 1 OF 8	
TITLE 412 FLOAT SKIDTUBE		SCALE NTS	
COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

NO. 10592
STOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NY NY 100-100000
NEW YORK POLICE
BUREAU OF INVESTIGATION
RECEIVED
JAN 10 1960
FBI NEW YORK



D3391-043 ASSEMBLY

RELEASED
07.11.21

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

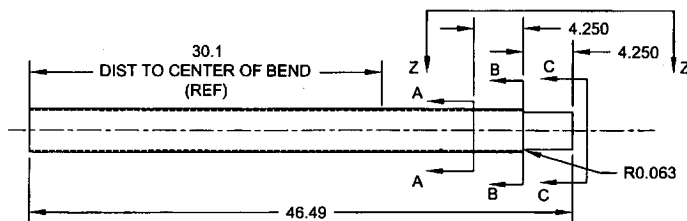
GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

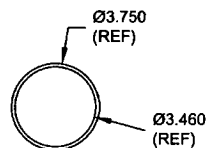
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	h	DRAWING NO.	REV. G
MFG. APPR.	h	D3391	SHEET 2 OF 8
APPROVED	h	TITLE	SCALE
DE APPR.	h	412 FLOAT SKIDTUBE	NTS
DATE	07.07.31	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED CO
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 2052

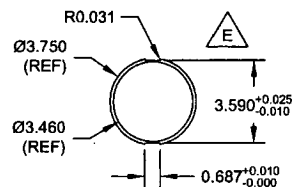
14
JACKSON COUNTY
ALABAMA
JACKSON COUNTY
JACKSON COUNTY
JACKSON COUNTY
JACKSON COUNTY
JACKSON COUNTY
JACKSON COUNTY



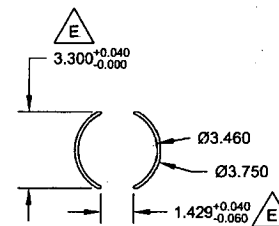
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



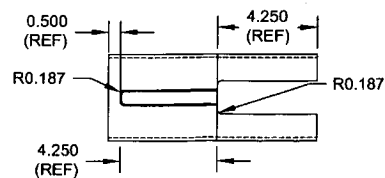
SECTION A-A
(SCALE 1:5)



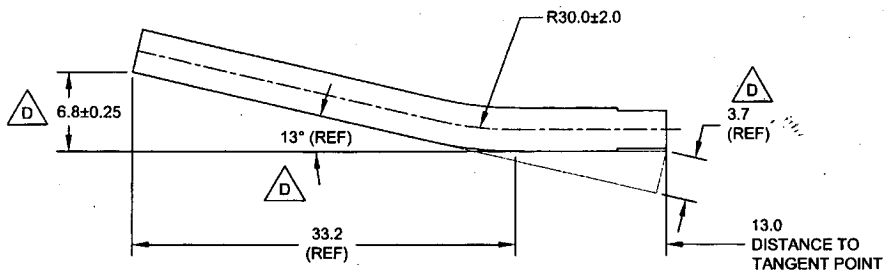
SECTION B-B
(SCALE 1:5)



SECTION C-C
(SCALE 1:5)



VIEW Z-Z
(SCALE 1:5)



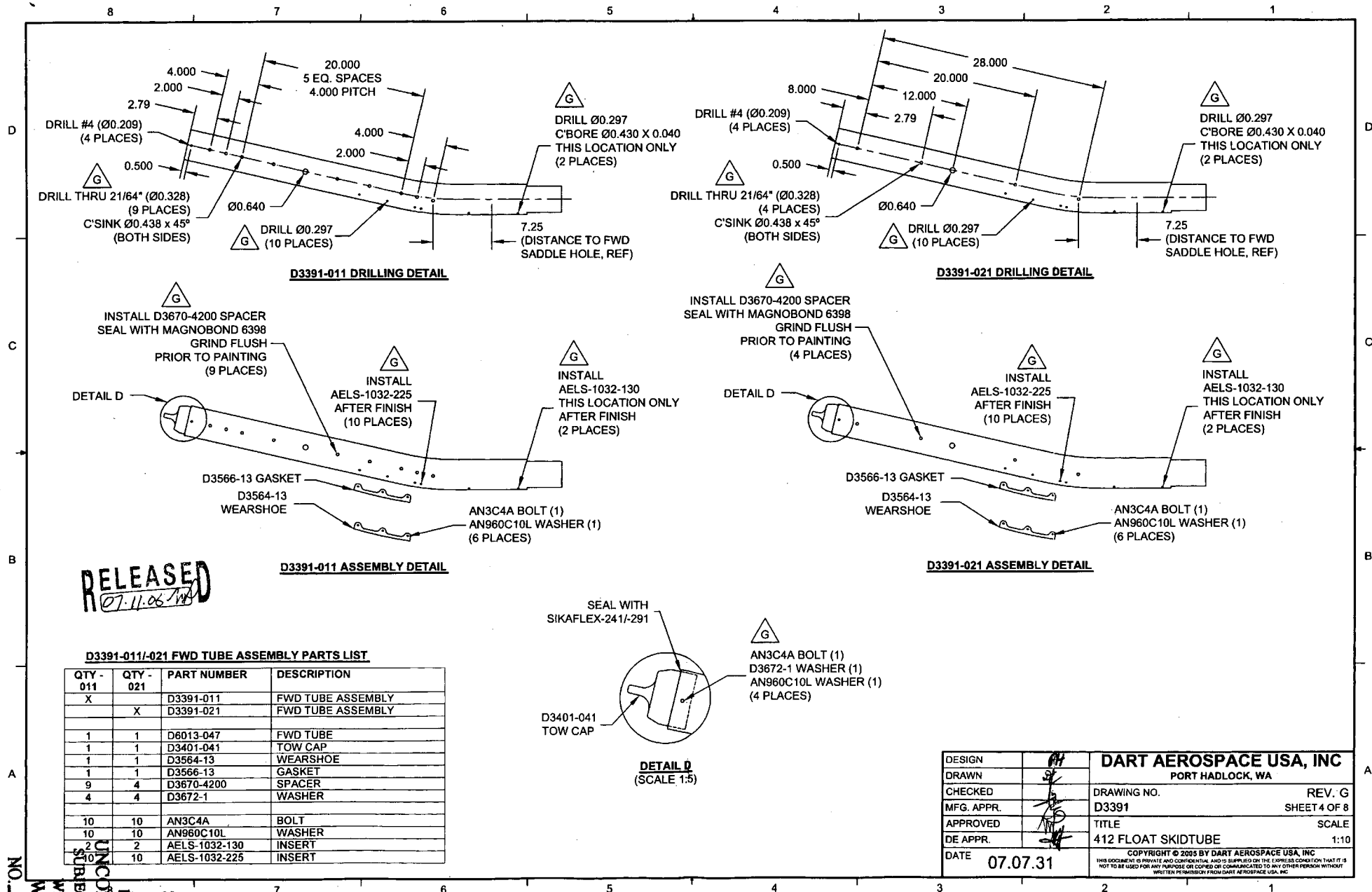
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)

RELEASED
07-11-06

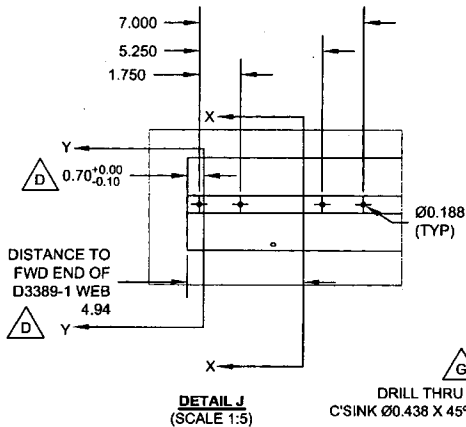
NO. 40505
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

DESIGN	<i>GH</i>	DART AEROSPACE USA, INC	
DRAWN	<i>JLC</i>	PORT HADLOCK, WA	
CHECKED	<i>JLC</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>JLC</i>	D3391	SHEET 3 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	412 FLOAT SKIDTUBE	1:1
DATE	07.07.31	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

4
M. J. KELLEY
MILWAUKEE POLICE
FURNISHED TO WISCONSIN NEWS
THIS COPY IS OFFICIAL COPY
ON REQUEST
RETURN TO
M. J. KELLEY

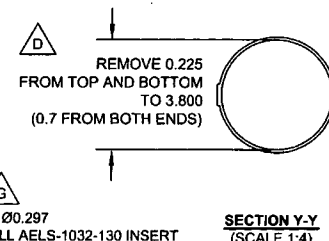
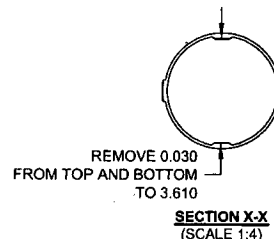
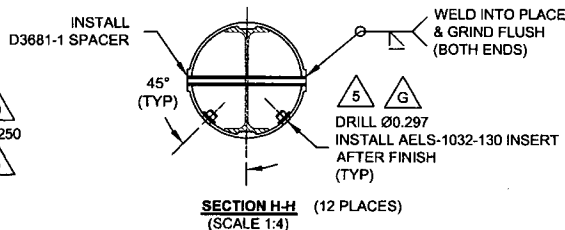
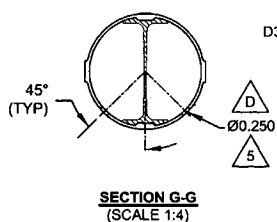
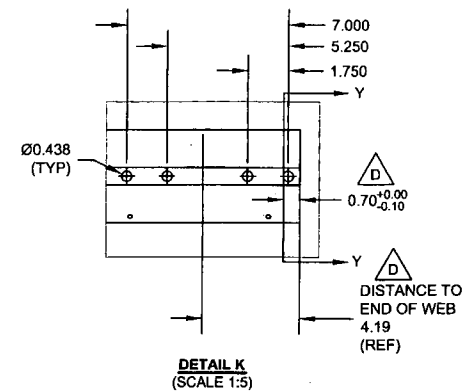


W. J. CANTER
ALL K. P. POLICE
20720210 V. W. CANTER
DISCOUNTED CO
18 W. CANTER
W. J. CANTER
W. J. CANTER



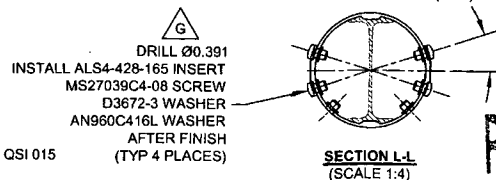
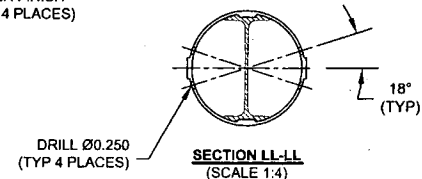
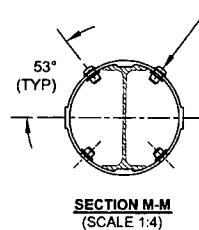
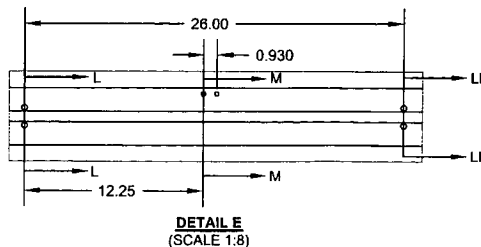
DRILL THRU 21/64" (Ø0.328)
C'SINK Ø0.438 X 45° (BOTH SIDES)
(12 PLACES)

D3391-013 ASSEMBLY DETAIL



D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY -013	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
12	D3681-1	SPACER
4	D3672-1	WASHER
4	D3672-3	WASHER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW



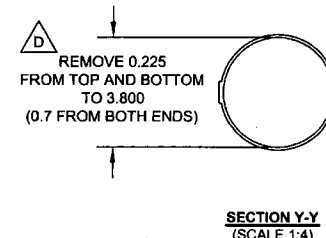
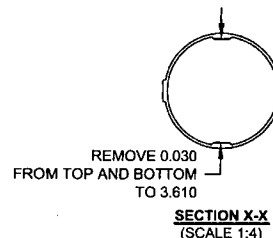
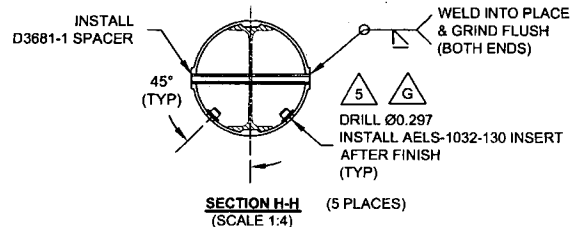
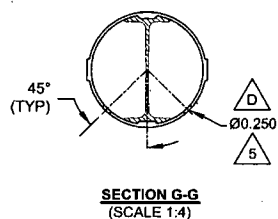
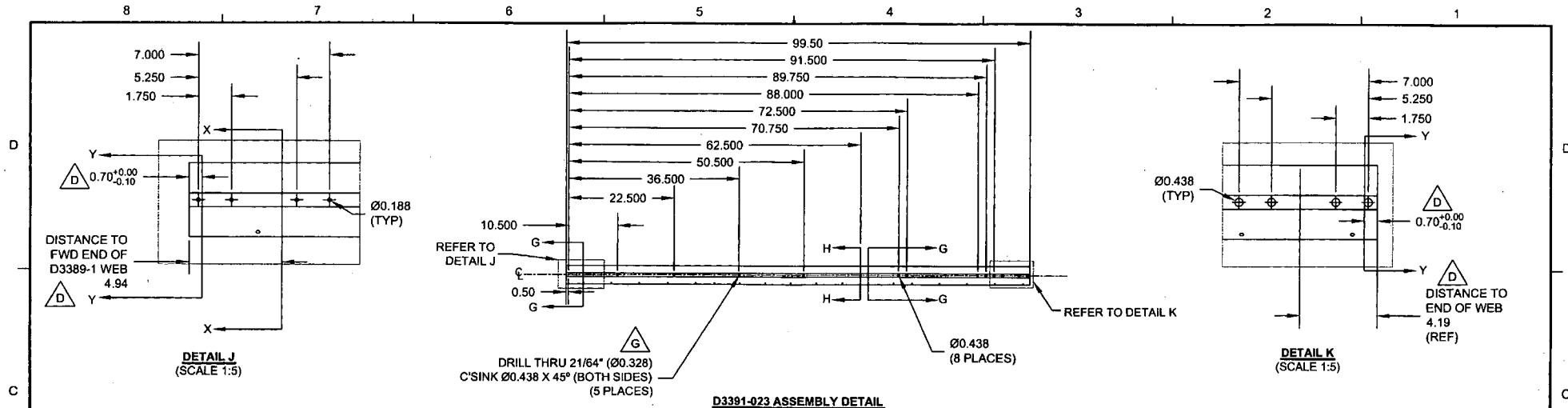
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	SP	PORT HADLOCK, WA	
CHECKED	SP	DRAWING NO.	REV. G
MFG. APPR.	SP	D3391	SHEET 5 OF 8
APPROVED	SP	TITLE	SCALE
DE APPR.	SP	412 FLOAT SKIDTUBE	1:20
DATE	07.07.31	COPYRIGHT © 2003 BY DART AEROSPACE USA, INC	

- D3391-013 MID TUBE ASSEMBLY**
- 1) MATERIAL MAKE FROM D2500-1-100 EXTRUSION
 - 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
 - 3) WELDING PER DART QSI 004

NO. 150523
WORK ORDER
CONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

RELEASED
07.11.06

4-1-1954
Y. K. COOK
MILWAUKEE
SHOULD BE WORKING
LINDA L. LOTTED COBA
MILWAUKEE
MILWAUKEE
MILWAUKEE



D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

1. MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
2. INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
3. WELDING: PER DART QSI 004

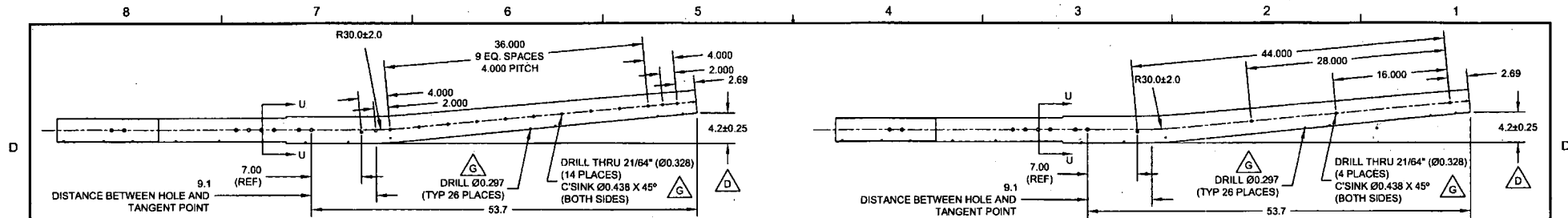
RELEASED
07.11.06/11

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	SP	PORT HADLOCK, WA	
CHECKED	3	DRAWING NO.	REV. G
MFG. APPR.	SP	D3391	SHEET 6 OF 8
APPROVED	SP	TITLE	SCALE
DE APPR.	SP	412 FLOAT SKIDTUBE	1:20
DATE	07.07.31	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

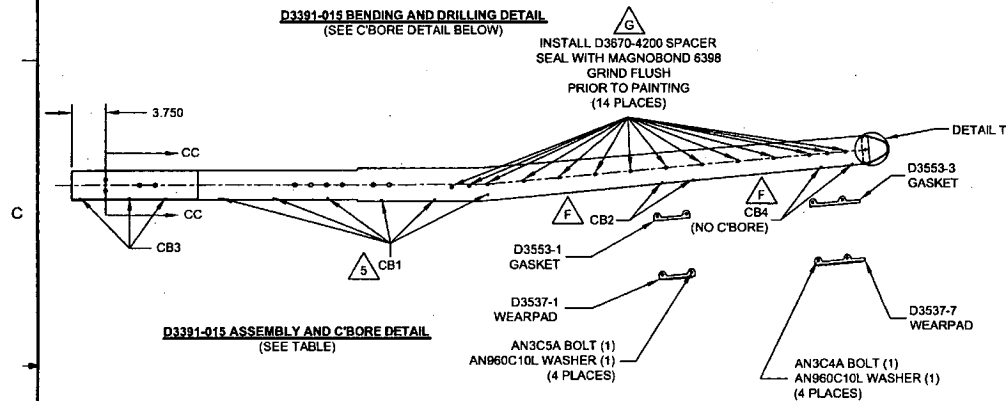
NO WORK ORDER
WITHOUT NOTICE
CONTROLLED COPY
SUBJECT TO AMENDMENT
ENGINEERING
RETURN TO
SHOP COPY

100-100000-100000
ALL INFORMATION CONTAINED
HEREIN IS UNCLASSIFIED
DATE 01-10-2001 BY 60322
AND 61300TED COM
REASON: 1.5
DATE 01-10-2001
BY 60322

M. W. K. ORDEY
MILITARY POLICE
SPECIAL VEHICLE
UNIONIZED CO
INVESTING
MILITARY
2H-4-00A



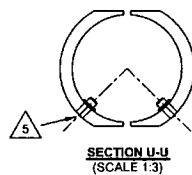
D3391-015 BENDING AND DRILLING DETAIL
(SEE C'BORE DETAIL BELOW)



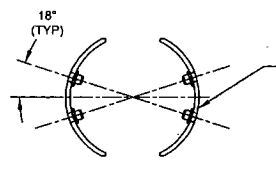
D3391-015 ASSEMBLY AND C'BORE DETAIL
(SEE TABLE)

D3391-015-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X		D3391-015	AFT TUBE ASSEMBLY
	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
14	14	AELS-1032-130	INSERT
12	12	AELS-1032-225	INSERT
4	4	ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER

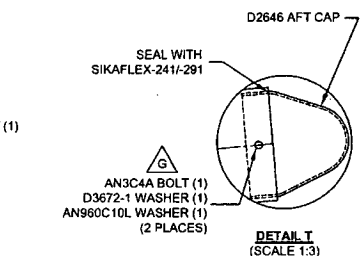


SECTION U-U
(SCALE 1:3)



SECTION CC-CC
(SCALE 1:3)

DRILL Ø0.391
C'BORE Ø0.516 X 0.040 DEEP
INSTALL ALS4-428-165 INSERT (1)
(4 PLACES)



DETAIL T
(SCALE 1:3)

RELEASED
07-11-06

C'BORE HOLES MARKED CB1-CB4 AS FOLLOWS AND INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'BORE	P/N
CB1	12	12	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

NO. 40525
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

DESIGN	PH	DART AEROSPACE USA, INC
DRAWN	SC	PORT HADLOCK, WA
CHECKED	JS	DRAWING NO. REV. G
MFG. APPR.	JS	D3391 SHEET 8 OF 8
APPROVED	JS	TITLE SCALE
DE APPR.	JS	412 FLOAT SKIDTUBE 1:12
DATE	07.07.31	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

W. H. WILSON
ALBANY, N. Y.
JANUARY 1, 1900
JANUARY 1, 1900
JANUARY 1, 1900
JANUARY 1, 1900
JANUARY 1, 1900